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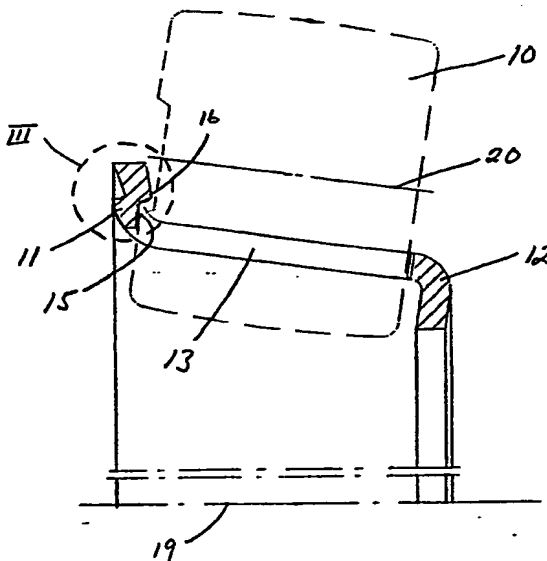
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54 **Roller bearing cage.**

57 A cage for the rollers in a roller bearing has two annular portions (11, 12) and intermediate bars (13). A protrusion (16) is provided on the side surface (15) of the one annular member 11 in connection to each cage pocket (14) for insertion into a recess in the adjacent roller end so as to retain the roller (10) in the cage pocket (14).

Fig. 1



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ROLLER BEARING CAGE

The invention relates to a roller bearing cage of the type defined in the introductory clause of claim 1.

A roller bearing cage of the type defined in the introductory clause of claim 1 is disclosed in US-A-4684268. In this prior art cage the protrusions are located inwardly of and spaced from the periphery of the side face. This means that the wear resistibility of the protrusions is rather limited and that the protrusions, due to their comparatively small dimensions, are rather sensitive to the type of burring used in the burring operation required after the pressing of the cage. There is also a risk that the die used during pressing of the protrusions becomes filled with oil and/or impurities, which negatively affects the tolerances of the dimensions of the protrusions. The protrusions are located comparatively far from the axes of the rollers, which negatively affects the capability of the protrusions to retain the rollers, and which requires a comparatively large recess for the protrusions in the rollers. Cages of this type can be made by pressing and stamping of sheet metal blanks.

The object of the present invention is to provide a roller bearing cage which is improved with regard to the above-mentioned disadvantages. This and other objects of the invention have been attained by the characterizing features stated in the claims following hereinafter.

The invention is described in detail in the following with reference to the accompanying drawings, in which Fig. 1 shows an axial section of a portion of a cage according to one embodiment of the invention.

Fig. 2 shows a view from the outside and radially inward of a portion of the outer circumference of the cage, wherein section I-I corresponding to Fig. 1 is indicated.

Fig. 3 shows on an enlarged scale the encircled portion of the cage in Fig. 1 denoted by III.

Fig. 4 shows a view of a portion of the cage according to reference IV in Fig. 3.

Figs. 5 and 6 show portions of a prior art cage corresponding to those in Figs. 3 and 4.

The cage shown in Figs. 1-4 is particularly intended to be used in a double row spherical roller bearing but can be used also in other types of roller bearings. In Fig. 1 a roller 10 for a double row spherical roller bearing is outlined and placed in its proper position in the cage. The axes 20 of the roller 10 forms an angle with the central axis 19 of the cage, whereby the axes of the rollers mounted in the cage define a cone with its apex on the axis 19, which coincides with the axis of the bearing. The cage comprises two closed annular por-

tions 11, 12 and a plurality of bars 13 defining cage pockets 14. The bars 13 extend mainly parallel to the axes 20 of adjacent rollers and are situated between the axis 19 of the cage and the axes 20 of the rollers. Thereby the bars 13 occupy a minimum of space between the rollers 10, and the contact against the envelope surfaces of the rollers has a great radial force component with respect to the cage, so that the cage is firmly centered in the bearing by its contact with the rollers. A flange 11 forming an integrated portion of the annular portion is arranged at one end of the cage and extends outwardly from the centre of the cage. Thereby the flange 11 does not significantly limit the space between the rows of rollers in a double row spherical roller bearing. The side surface 15 of the flange 11 which is facing the pockets 14 can be dimensioned to contact the rollers mounted in the cage on their end surfaces facing the flange. The flange 11 suitably extends as far radially outwards that the extension of the roller axis 20 intersects the flange surface which contacts the rollers, whereby maximum roller guiding ability is achieved.

Since the cage bars 13 are situated radially inside the roller axes 20 with respect to the cage axis 19 and thereby do not limit the radially outward mobility of the rollers, the cage is in a generally known manner provided with an arrangement for keeping the rollers in the cage also when they are not enclosed in an outer ring. In the embodiment disclosed in US-A-4684268 and shown in Figs. 5 and 6 this arrangement comprises protrusions 21 on the flange 11' extending towards the roller pockets and having a surface 22 facing said pockets. Each protrusion is situated so as to face the middle of each pocket. The protrusion is intended for insertion in a recess in the end surface of a roller situated in the opposing pocket, whereby the shape of the protrusion allows the roller to be snapped into position in the pocket by pressing the end surface of the roller radially inwards past the protrusion 21, which procedure is possible because of the resiliency of the cage.

As shown in Fig. 6 the surface 22 is located completely radially inwardly of the periphery of the flange 11' in the prior art cage. This means that the diameter of the circular pin used for pressing the protrusions 21 during the forming thereof, i.e. the punch, is small. Thus, the pin might be broken or plasticized after a number of impressions. Since a press die having a closed recess must be used during the pressing operation there is a risk that this small recess is filled with oil and/or impurities, which affects the shape of the protrusions, i.e. makes it difficult to maintain the tolerances of the

dimensions of the protrusions unchanged. This means that the recess must be continuously cleaned, for instance by compressed air. Further, due to their limited dimensions the wear resistibility of the protrusions 21 is rather low. The limited dimensions also make the protrusions sensitive to the type of deburring used after the pressing operation which means that highly material-removing methods such as chemical deburring cannot be used. The protrusions 21 must also be located rather far from the axes 20 of the rollers which negatively affects the capability of the protrusions to retain the rollers. Such a location far from the roller axes also requires a large recess in the rollers for the protrusions, which is a disadvantage from a manufacturing point of view.

According to the invention the protrusions 16 on the side surface 15 are arranged to extend in a direction away from the bars 13 substantially all the way to the radially outer periphery 17 of the side surface 15. This is obtained by positioning the whole or substantially the whole pressing surface of the punch, i.e. the circular pin, against the flange 11, whereupon the radially outer portion of the flange is cut off so as to obtain a smooth peripheral edge 17. In a preferred embodiment the surface 18 on the protrusions 16 comprises 55-90 % of the surface of the corresponding circle, said surface 18 having substantially the shape of a segment of a circle.

A protrusion produced according to the invention can be made thicker and thus become considerably more resistant to wear than the prior art protrusion shown in Figs. 5 and 6, i.e. more reliable as to its function. Further, the life of the punch becomes longer. Due to the fact that the recess in the press die is comparatively large, impurities and/or oil collected in this recess do not significantly affect the dimensions of the protrusions which makes it comparatively easy to maintain the tolerances thereof unchanged. It is also possible to locate protrusions according to the invention closer to the axes of the rollers which improves the capability of the protrusions to retain the rollers in their pockets and requires only a small recess for the protrusion in the roller end surface.

In the preferred embodiment the surface 18 of the protrusions 16 coincides with the side surface 15 at the periphery 17. This means that the transition denoted by 23 in Fig. 5 between the side surface 15 and the surface 18 is completely eliminated. As shown in Fig. 3 the distance between the surface 18 and the side surface 15 increases successively in a direction away from the periphery 17.

Further, in the preferred embodiment, the surface 18 is provided with two surface portions 18a, 18b of which the radially inner surface portion 18b

is planar and parallel to the outer surface of the flange 11 and forms a smaller angle with the side surface 15 than the radially outer surface portion 18a. Alternatively, instead of being generally convex as shown in Fig. 3 the surface 18 might be generally concave when seen in a radial direction.

In order to ensure that the roller takes the correct position in relation to the pocket and the protrusion 16 during the snap action, recesses 24 are in a manner known per se provided at the opposite side of the cage in relation to the flange 11 in the annular portion 12. The recesses oppose the protrusions 16. Therewith the end portion of each roller can be directed correctly with respect to the protrusion 16 by being placed in the recess. The existence of the recess also allows the roller to be axially displaced from the protrusion 16 in the initial stage of the snapping procedure, which simplifies mounting. The envelope surfaces of the rollers are not subjected to any pressure during the mounting procedure, which diminishes the risk for roller damages. A convex edge 25 is suitably provided on either side of each recess 24, which edge extends towards the interior of the pocket. This arrangement prevents the edges of the roller from contacting the cage when the rollers are skewed, thereby diminishing wear in the bearing.

Also the flange 11 has suitably a convex surface facing the rollers. The surface has the shape of a torus in order to give a suitable contact against the adjacent roller ends. A flange is preferably arranged also in connection to the annular portion 12. Such a flange gives the cage an increased stability and strength. If the flange extends inwardly, the whole cage may be formed in a simple manner in a pressing and punching tool.

The cage in a double row spherical roller bearing is preferably supplemented with a loose guide ring, not shown which encloses the flange 11 of the cages of both rows of rollers. Fig. 1 shows the cage of one row of rollers only. The guide ring cooperates with the cages in guiding the rollers.

If a roller in the loaded zone in the bearing has a tendency to skew it will be guided by the contact with the guide ring. At the same time, the guide ring will be displaced toward the loaded zone of the bearing by being squeezed into a wedge shaped space between the ends of the rollers of both of rollers. Therewith the guide ring displaces the cage radially towards the loaded zone of the bearing due to its contact with the cage in the unloaded zone so that the play of the rollers in the cage pockets in the loaded zone decreases, whereby the guidance of the rollers is further improved.

Claims

1. A cage for a row of rollers (10) in a roller bearing comprising first and second closed annular portions (11, 12) and a plurality of bars (13) extending therebetween, said bars defining cage pockets (14), wherein the first annular portion (11) has a side face (15) facing the rollers (10) and wherein protrusions (16) are provided on said side face, said protrusions extending generally toward the second annular portion (12), characterized in that the protrusions (16) extend in a direction away from the bars (13) substantially as far as to the radially outer periphery (17) of the side face (15).

2. A roller cage according to claim 1, wherein the surface (18) of the protrusions (16) facing the rollers (10) substantially coincides with the side face (15) of the first annular portion (11) at its radially outer periphery (17).

3. A roller cage according to claim 1 or 2, wherein the surface (18) of the protrusions (16) facing the rollers (10) successively increase their distance from the side face (15) of the first annular portion (11) in the direction from the radially outer periphery (17) of the protrusions (16).

4. A roller cage according to any of claims 1-3, wherein the surface (18) of the protrusions (16) facing the rollers (10) has two surface portions (18a, 18b), the radially inner one (18b) of said surface portions forming a smaller angle with the side face (15) of the first annular portion (11) than the radially outer one (18a) of said surface portions.

5. A roller cage according to any of claims 1-3, wherein the surface (18) of the protrusions (16) facing the rollers (10) is generally concave when seen in a radial direction.

6. A roller cage according to any of the preceding claims, wherein the surface (18) of the protrusions (16) facing the rollers (10) has substantially the shape of a segment of a circle.

7. A roller cage according to claim 6, wherein the segment of the circle comprises a substantial portion of the surface of corresponding circle, preferably 55-90 % of said surface.

8. A roller cage according to any of the preceding claims, wherein the bars (13) extend substantially parallel to the axes of adjacent rollers (10) and are located between the axis (19) of the roller bearing and the axes (20) of the rollers.

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Fig. 3

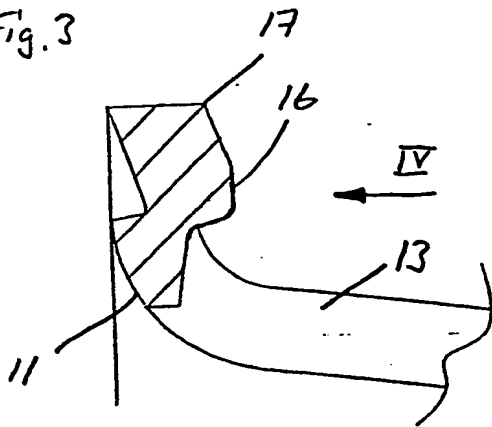


Fig. 4

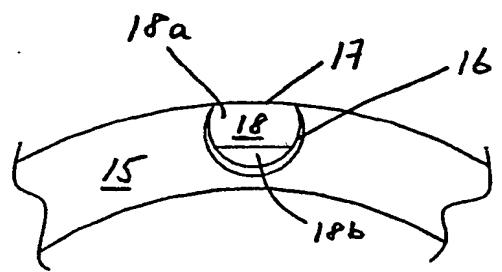


Fig. 5

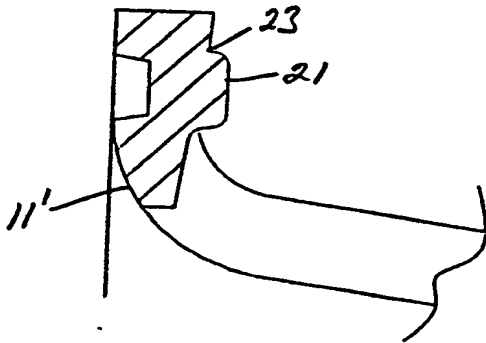
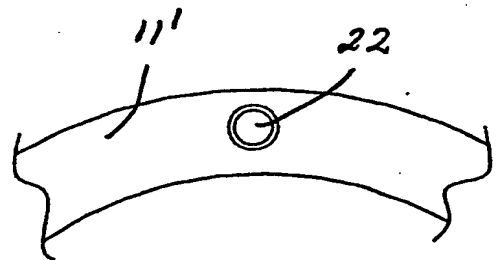


Fig. 6





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EUROPEAN SEARCH REPORT

Application Number

EP 89 85 0285

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl.5)
D,A	US-A-4 684 268 (A. SAHLGREN et al.) * claims 1,2; figure 1 * ---	1	F 16 C 33/46
A	DE-A-2 031 535 (TEXTRON INC.) -----		
			TECHNICAL FIELDS SEARCHED (Int. Cl.5)
			F 16 C
The present search report has been drawn up for all claims			
Place of search BERLIN		Date of completion of the search 20-03-1990	Examiner HOFFMANN M.P.
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